



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

3119

**D3957-044**  
**Job Sheet 177266**



Part No: D3957-044

Job Qty: 1 ea

Part Name: Hinge Assembly, Door RH Lower



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Template:

Job Tracking No:

Job Created: 5/9/18

Created By: Marie Lajeunesse

Due Date: 5/11/18

Description:

Type: SOLD

Note: DWG REV A IPP RevA: New issue DD verified by:EC

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off       |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|----------------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |                |
| 90    | Start up Operation | 1 Ea  | 5/11/18    | 5/11/18  | 0.00      | 0.00    | Start Up Small Fab-4  |           | JB             |
| 110   | Small Fab          | 1 pcs | 5/11/18    | 5/11/18  | 0.00      | 0.20    | Small Fab-9           |           | JB DAS         |
| 120   | QC                 | 1 pcs | 5/11/18    | 5/11/18  | 0.00      | 0.00    | QC5                   |           | 38             |
| 130   | Packaging          | 1 pcs | 5/11/18    | 5/11/18  | 0.00      | 0.00    | Packaging3-2          | Sold      | MAY 09 2018    |
| 140   | QC21-SA            | 1 Ea  | 5/11/18    | 5/11/18  | 0.00      | 0.00    | QC21                  |           | 21 MAY 09 2018 |

Part Op  
Descriptions: 110 - 1-Install Helicoil in d3957-4 2-Install Rod end and Nut Loosely

### Job BOM

| Part / Item | Component Name       | Quantity     | Operation             | Container |
|-------------|----------------------|--------------|-----------------------|-----------|
| D3518-3     | Ball Joint End       | 1 Ea (1 ea)  | 90-Start up Operation | 5069758   |
| D3957-4     | Hinge, Door RH Lower | 1 pcs (1 ea) | 90-Start up Operation | B95326    |
| MS124818    | Helicoil             | 1 pcs (1 ea) | 90-Start up Operation | PM12952   |
| NAS509-6    | Nut                  | 1 Ea (1 ea)  | 90-Start up Operation | 5069759   |

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | D3518-3        | 1        | 0         | 0         |
|                       | D3957-4        | 1        | 0         | 0         |
|                       | MS124818       | 1        | 12        | 0         |
|                       | NAS509-6       | 1        | 0         | 0         |

### Part Specifications

Specifications could not be found.

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

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| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                                                | <b>DISPOSITION</b><br><br>Re: _____<br><br>U<br>Suspected Und _____ |                                                            | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><table style="width:100%;"> <tr> <td style="width:33%;">Cross tube <input type="checkbox"/></td> <td style="width:33%;">Water Jet <input type="checkbox"/></td> <td style="width:33%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>" Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> |  |                                      |                                             | Cross tube <input type="checkbox"/>      | Water Jet <input type="checkbox"/>       | Engineering <input type="checkbox"/>      | " Fab <input type="checkbox"/>  | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> |                                 | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/>    |                                       | Supplier <input type="checkbox"/>              |                                    |                                               |                                        |                                   |                                 |                                               |                                         |                                       |                                   |                                                 |                                                            |                                            |                                   |                                          |                                |                                        |                                     |                                             |                                           |                                   |                                      |                                  |                                           |                                  |                                     |                                        |                                 |                              |                                              |                                             |                                                          |                                  |                                     |                                              |                                        |                                      |                                           |                                           |                                                |               |  |  |                                        |                                   |
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| <div style="position: relative;"> <div style="position: absolute; top: 10%; left: 10%;"> <b>Description Work Order Deviation</b> </div> <div style="position: absolute; top: 30%; left: 30%; transform: rotate(-45deg);"> <br/>           Container No: S069775<br/>           Part: D3957 - 044<br/>           Job No: 177266<br/>           Serial No/ Batch: S069775<br/>           Revision: A<br/>           Inspector: _____         </div> <div style="position: absolute; top: 60%; left: 10%;">           Date: 05/09/18         </div> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                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| <div style="position: relative;"> <div style="position: absolute; top: 10%; left: 10%;"> <b>Root Cause</b> </div> <table style="width:100%;"> <tr> <td style="width:16%;">Environment <input type="checkbox"/></td> <td style="width:16%;">No Re-verification <input type="checkbox"/></td> <td style="width:16%;">Pressure/Forced <input type="checkbox"/></td> <td style="width:16%;">Temperature/Cu. <input type="checkbox"/></td> <td style="width:16%;">Positioned Wrong <input type="checkbox"/></td> </tr> <tr> <td>Design <input type="checkbox"/></td> <td>Operator <input type="checkbox"/></td> <td>Bending <input type="checkbox"/></td> <td>Set-up <input type="checkbox"/></td> <td>Outside Dimensions <input type="checkbox"/></td> </tr> <tr> <td>Doc/Data <input type="checkbox"/></td> <td>Offset/Setup <input type="checkbox"/></td> <td>Centre Not Concentric <input type="checkbox"/></td> <td>BOM/Route <input type="checkbox"/></td> <td>Over/Under tolerance <input type="checkbox"/></td> </tr> <tr> <td>Equip/Tooling <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td>Cracks <input type="checkbox"/></td> <td>Broken/Damage/Defect <input type="checkbox"/></td> <td>Part Incorrect <input type="checkbox"/></td> </tr> <tr> <td>Handling/Pre <input type="checkbox"/></td> <td>Training <input type="checkbox"/></td> <td>Crimp/Kink/Ripple/Wave <input type="checkbox"/></td> <td>Inspection Incomplete/Unqualified <input type="checkbox"/></td> <td>Part Lost/Missing <input type="checkbox"/></td> </tr> <tr> <td>Material <input type="checkbox"/></td> <td>Use for Testing <input type="checkbox"/></td> <td>Cuffs <input type="checkbox"/></td> <td>Contamination <input type="checkbox"/></td> <td>Part Moved <input type="checkbox"/></td> </tr> <tr> <td>Internal Transport <input type="checkbox"/></td> <td>Poor Information <input type="checkbox"/></td> <td>Crushing <input type="checkbox"/></td> <td>Countersink <input type="checkbox"/></td> <td>Drawing <input type="checkbox"/></td> </tr> <tr> <td>Tribal Knowledge <input type="checkbox"/></td> <td>Rushing <input type="checkbox"/></td> <td>Heat Treat <input type="checkbox"/></td> <td>Cut Too Short <input type="checkbox"/></td> <td>Finish <input type="checkbox"/></td> </tr> <tr> <td>LOA <input type="checkbox"/></td> <td>Product Improvement <input type="checkbox"/></td> <td>Wave/Twist in Tube <input type="checkbox"/></td> <td>Instructions Incomplete/Unclear <input type="checkbox"/></td> <td>Misread <input type="checkbox"/></td> </tr> <tr> <td>Substation <input type="checkbox"/></td> <td>Process Improvement <input type="checkbox"/></td> <td>Marks/Chatter <input type="checkbox"/></td> <td>Drill Holes <input type="checkbox"/></td> <td>Turning Sequence <input type="checkbox"/></td> </tr> <tr> <td>Past Expiry Date <input type="checkbox"/></td> <td>Manufacturing Process <input type="checkbox"/></td> <td colspan="3" rowspan="2">OTHER : _____</td> </tr> <tr> <td>Misidentified <input type="checkbox"/></td> <td>Past Due <input type="checkbox"/></td> </tr> </table> </div> |                                                |                                                                     |                                                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  | Environment <input type="checkbox"/> | No Re-verification <input type="checkbox"/> | Pressure/Forced <input type="checkbox"/> | Temperature/Cu. <input type="checkbox"/> | Positioned Wrong <input type="checkbox"/> | Design <input type="checkbox"/> | Operator <input type="checkbox"/>          | Bending <input type="checkbox"/> | Set-up <input type="checkbox"/> | Outside Dimensions <input type="checkbox"/>  | Doc/Data <input type="checkbox"/> | Offset/Setup <input type="checkbox"/> | Centre Not Concentric <input type="checkbox"/> | BOM/Route <input type="checkbox"/> | Over/Under tolerance <input type="checkbox"/> | Equip/Tooling <input type="checkbox"/> | Supplier <input type="checkbox"/> | Cracks <input type="checkbox"/> | Broken/Damage/Defect <input type="checkbox"/> | Part Incorrect <input type="checkbox"/> | Handling/Pre <input type="checkbox"/> | Training <input type="checkbox"/> | Crimp/Kink/Ripple/Wave <input type="checkbox"/> | Inspection Incomplete/Unqualified <input type="checkbox"/> | Part Lost/Missing <input type="checkbox"/> | Material <input type="checkbox"/> | Use for Testing <input type="checkbox"/> | Cuffs <input type="checkbox"/> | Contamination <input type="checkbox"/> | Part Moved <input type="checkbox"/> | Internal Transport <input type="checkbox"/> | Poor Information <input type="checkbox"/> | Crushing <input type="checkbox"/> | Countersink <input type="checkbox"/> | Drawing <input type="checkbox"/> | Tribal Knowledge <input type="checkbox"/> | Rushing <input type="checkbox"/> | Heat Treat <input type="checkbox"/> | Cut Too Short <input type="checkbox"/> | Finish <input type="checkbox"/> | LOA <input type="checkbox"/> | Product Improvement <input type="checkbox"/> | Wave/Twist in Tube <input type="checkbox"/> | Instructions Incomplete/Unclear <input type="checkbox"/> | Misread <input type="checkbox"/> | Substation <input type="checkbox"/> | Process Improvement <input type="checkbox"/> | Marks/Chatter <input type="checkbox"/> | Drill Holes <input type="checkbox"/> | Turning Sequence <input type="checkbox"/> | Past Expiry Date <input type="checkbox"/> | Manufacturing Process <input type="checkbox"/> | OTHER : _____ |  |  | Misidentified <input type="checkbox"/> | Past Due <input type="checkbox"/> |
| Environment <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   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| Design <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        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| Doc/Data <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      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| Equip/Tooling <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 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| Handling/Pre <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | Training <input type="checkbox"/>              | Crimp/Kink/Ripple/Wave <input type="checkbox"/>                     | Inspection Incomplete/Unqualified <input type="checkbox"/> | Part Lost/Missing <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  |                                      |                                             |                                          |                                        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| Material <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | Use for Testing <input type="checkbox"/>       | Cuffs <input type="checkbox"/>                                      | Contamination <input type="checkbox"/>                     | Part Moved <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |                                      |                                             |                                          |                                        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| Internal Transport <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | Poor Information <input type="checkbox"/>      | Crushing <input type="checkbox"/>                                   | Countersink <input type="checkbox"/>                       | Drawing <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |  |                                      |                                             |                                          |                                        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| Tribal Knowledge <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | Rushing <input type="checkbox"/>               | Heat Treat <input type="checkbox"/>                                 | Cut Too Short <input type="checkbox"/>                     | Finish <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  |                                      |                                             |                                          |                                        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| LOA <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | Product Improvement <input type="checkbox"/>   | Wave/Twist in Tube <input type="checkbox"/>                         | Instructions Incomplete/Unclear <input type="checkbox"/>   | Misread <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |  |                                      |                                             |                                          |                                        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| Substation <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | Process Improvement <input type="checkbox"/>   | Marks/Chatter <input type="checkbox"/>                              | Drill Holes <input type="checkbox"/>                       | Turning Sequence <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |  |                                      |                                             |                                          |                                        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| Past Expiry Date <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | Manufacturing Process <input type="checkbox"/> | OTHER : _____                                                       |                                                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  |                                      |                                             |                                          |                                        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| Misidentified <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | Past Due <input type="checkbox"/>              |                                                                     |                                                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  |                                      |                                             |                                          |                                        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